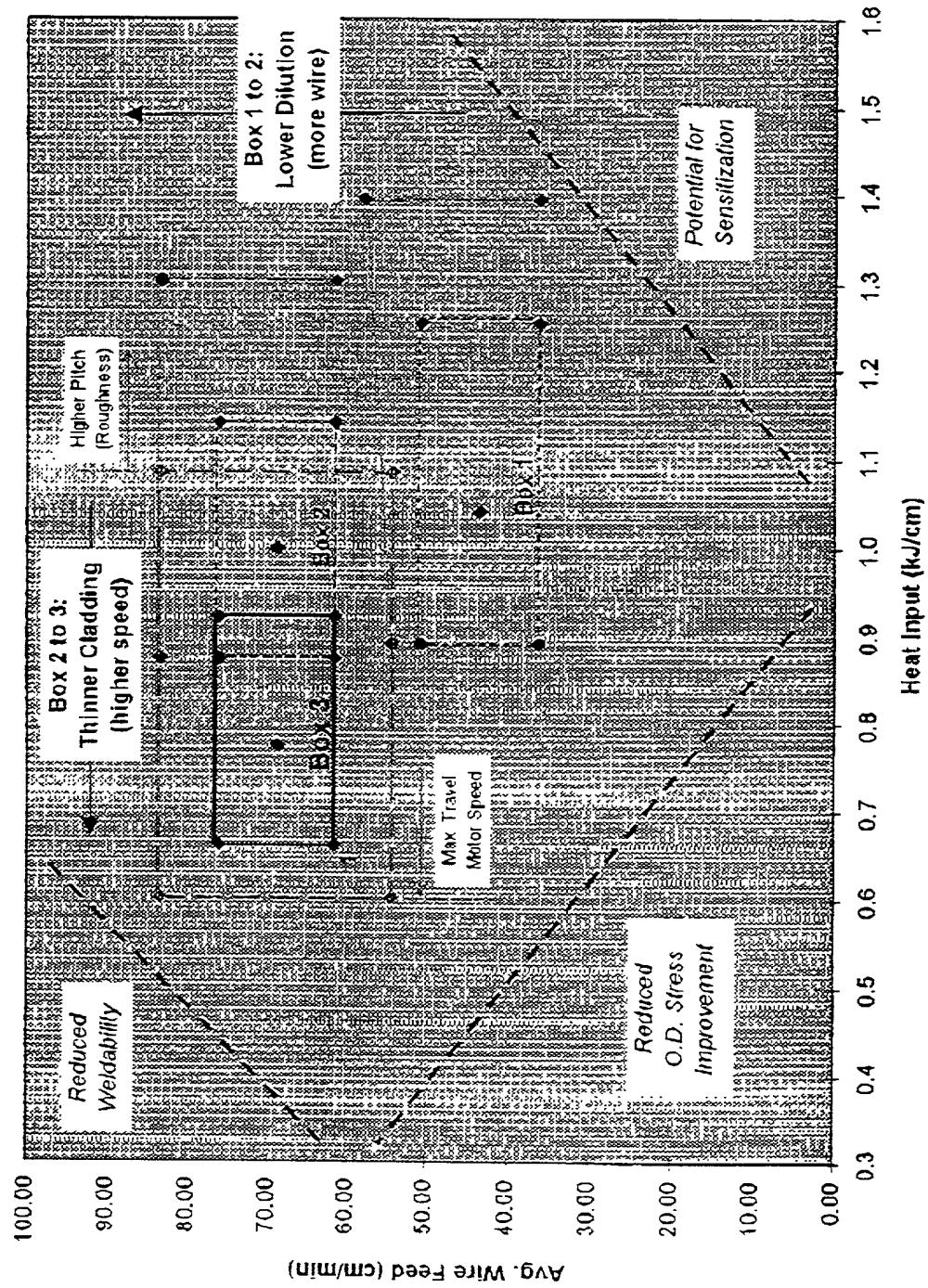


FIG. 1

Heat Boxes 1, 2, 3 (with Reference Points)



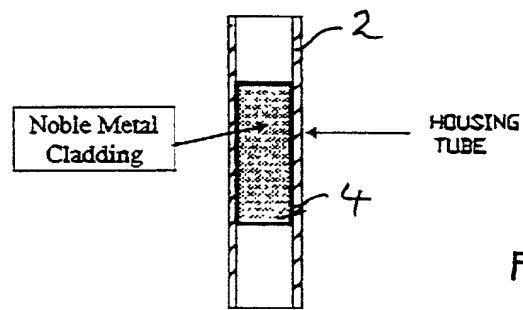


FIG. 2A

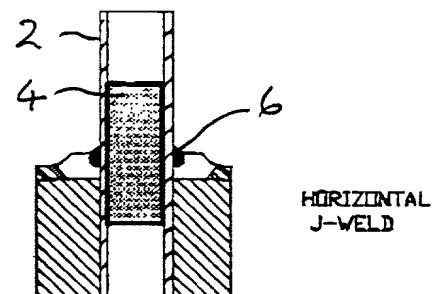


FIG 2B

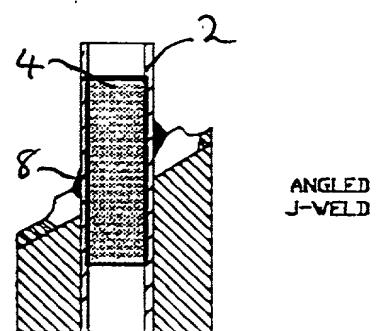
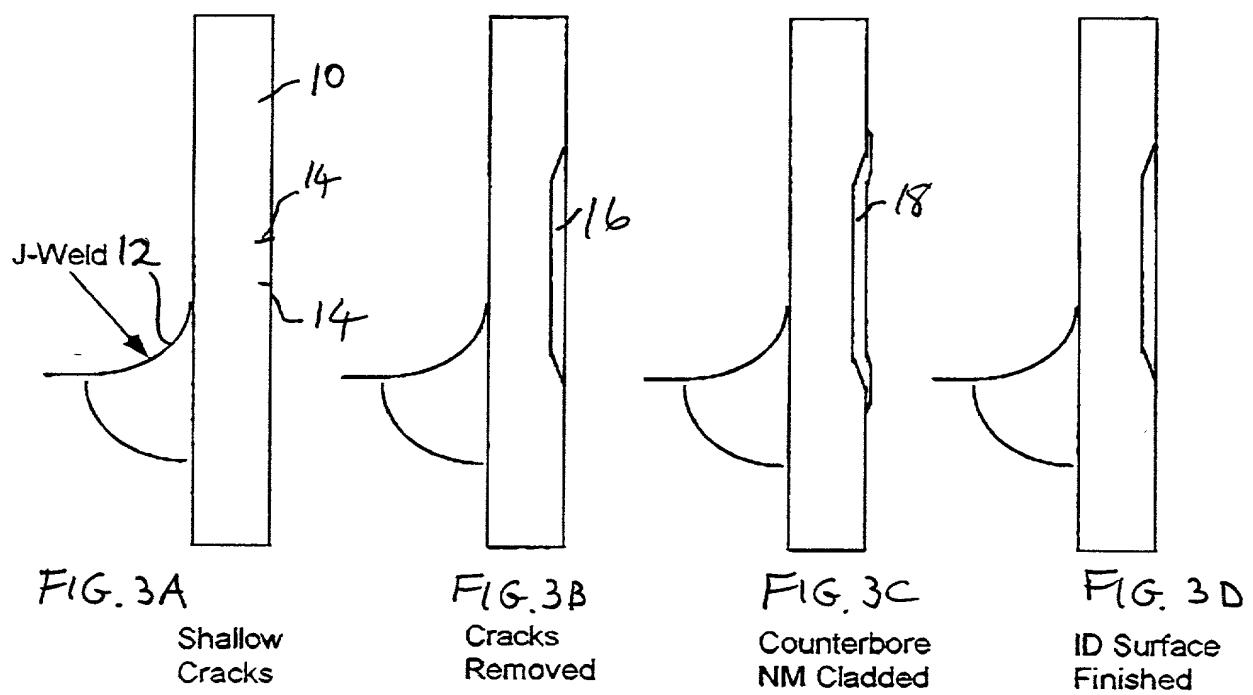
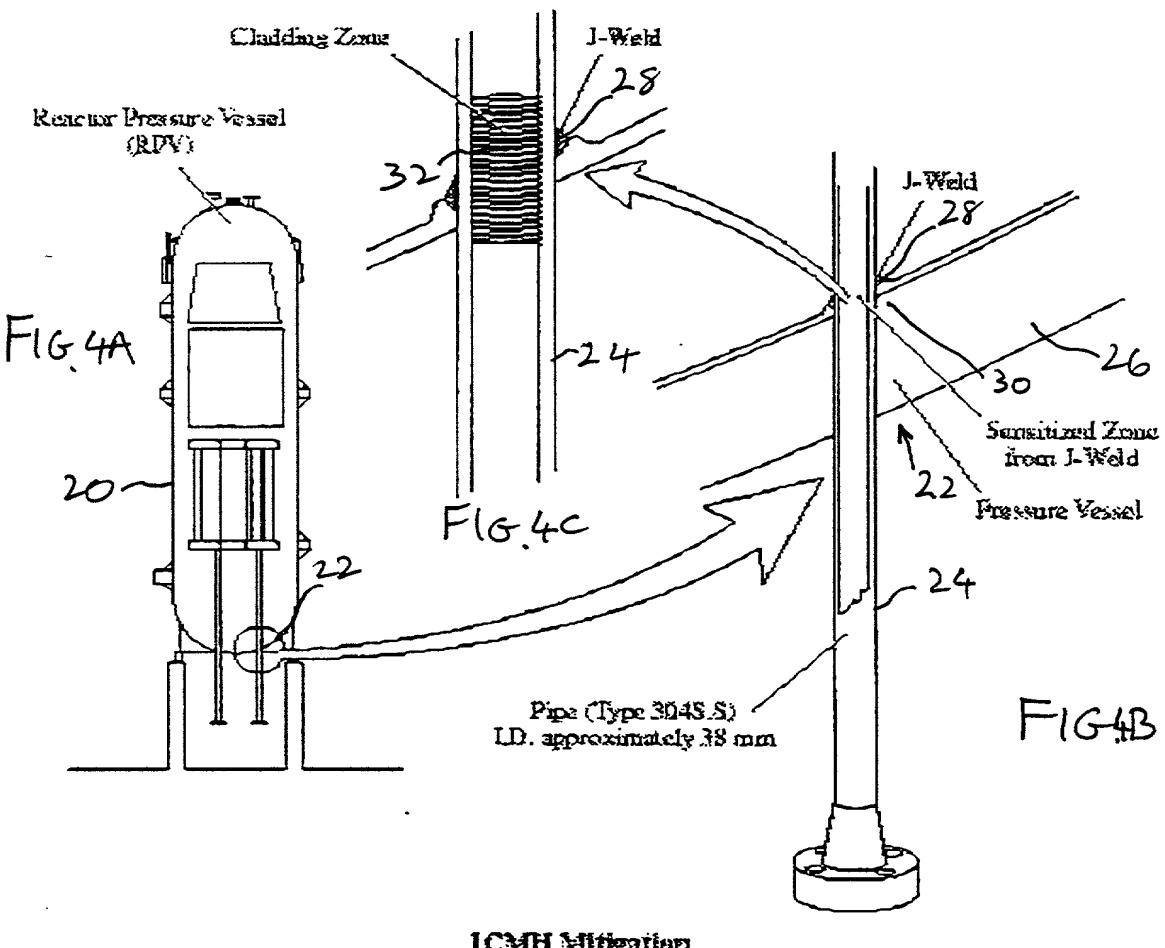


FIG 2C





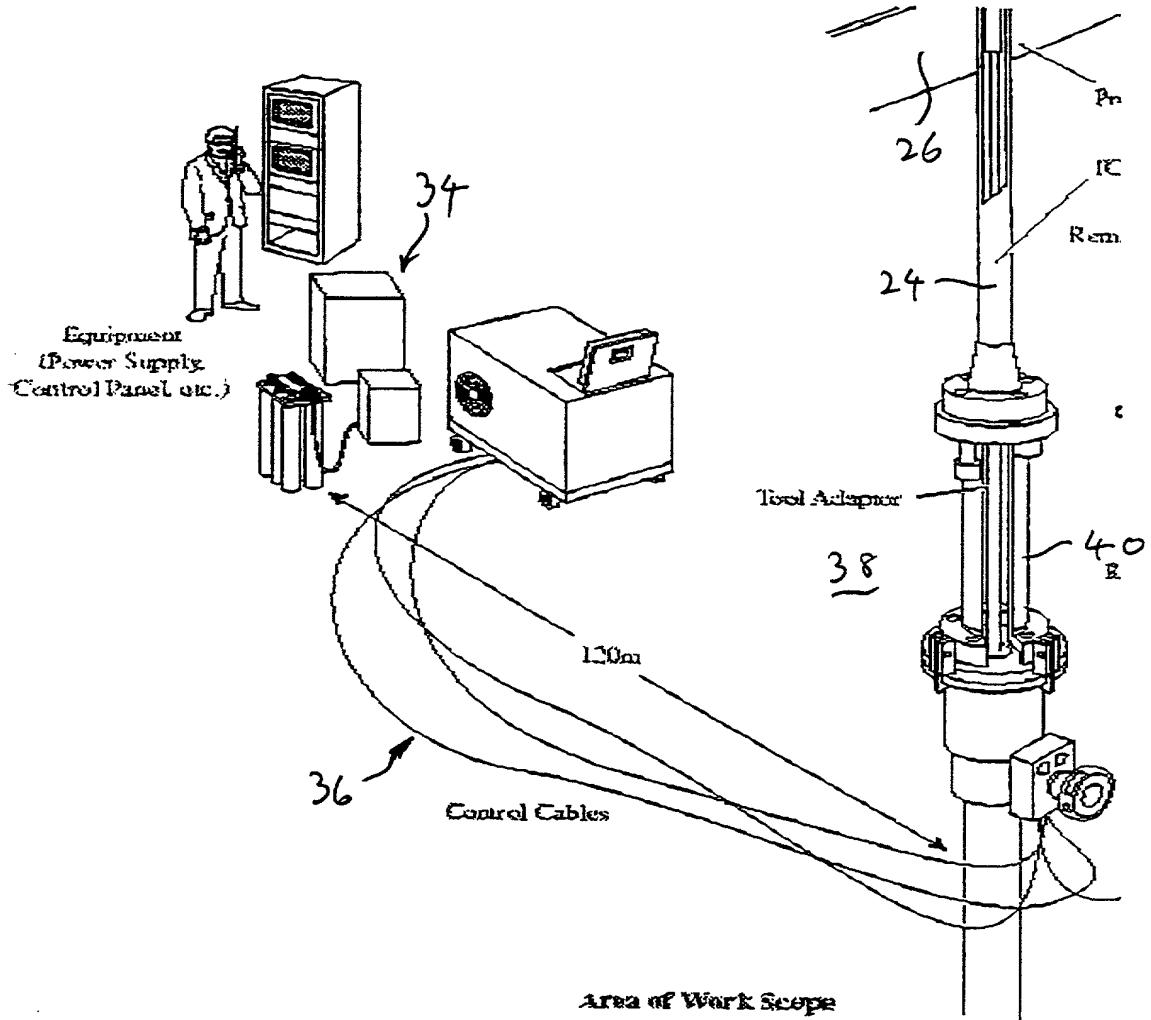


FIG. 5

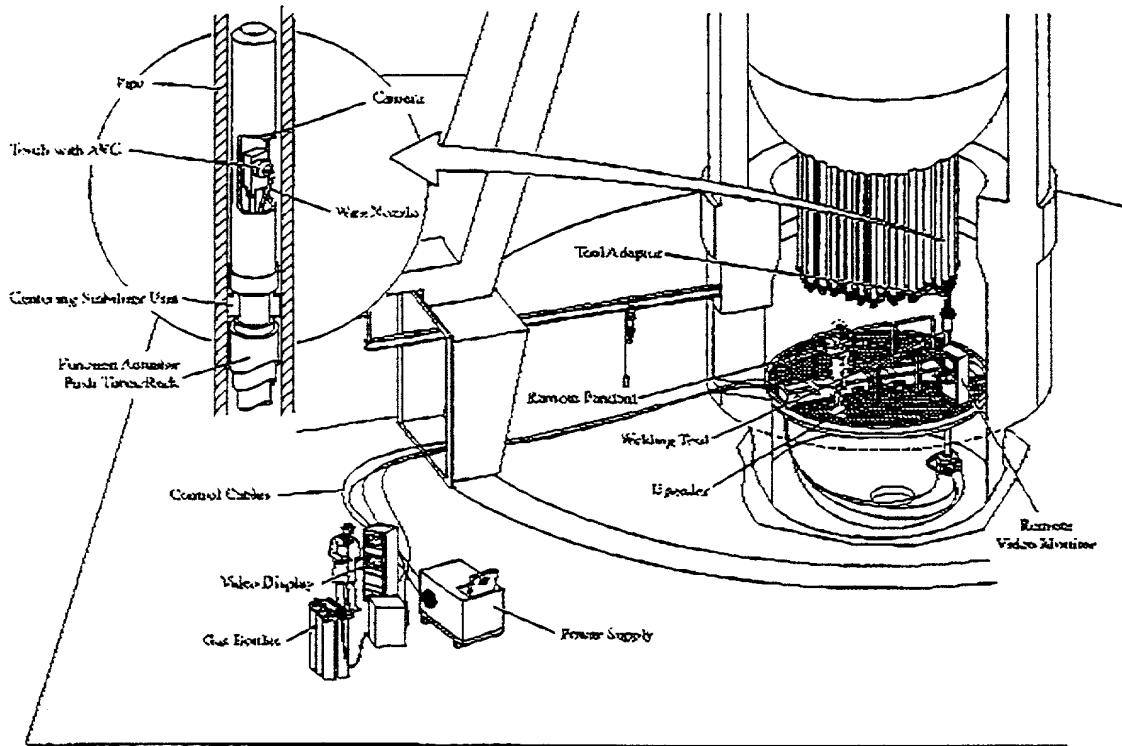


FIG. 6

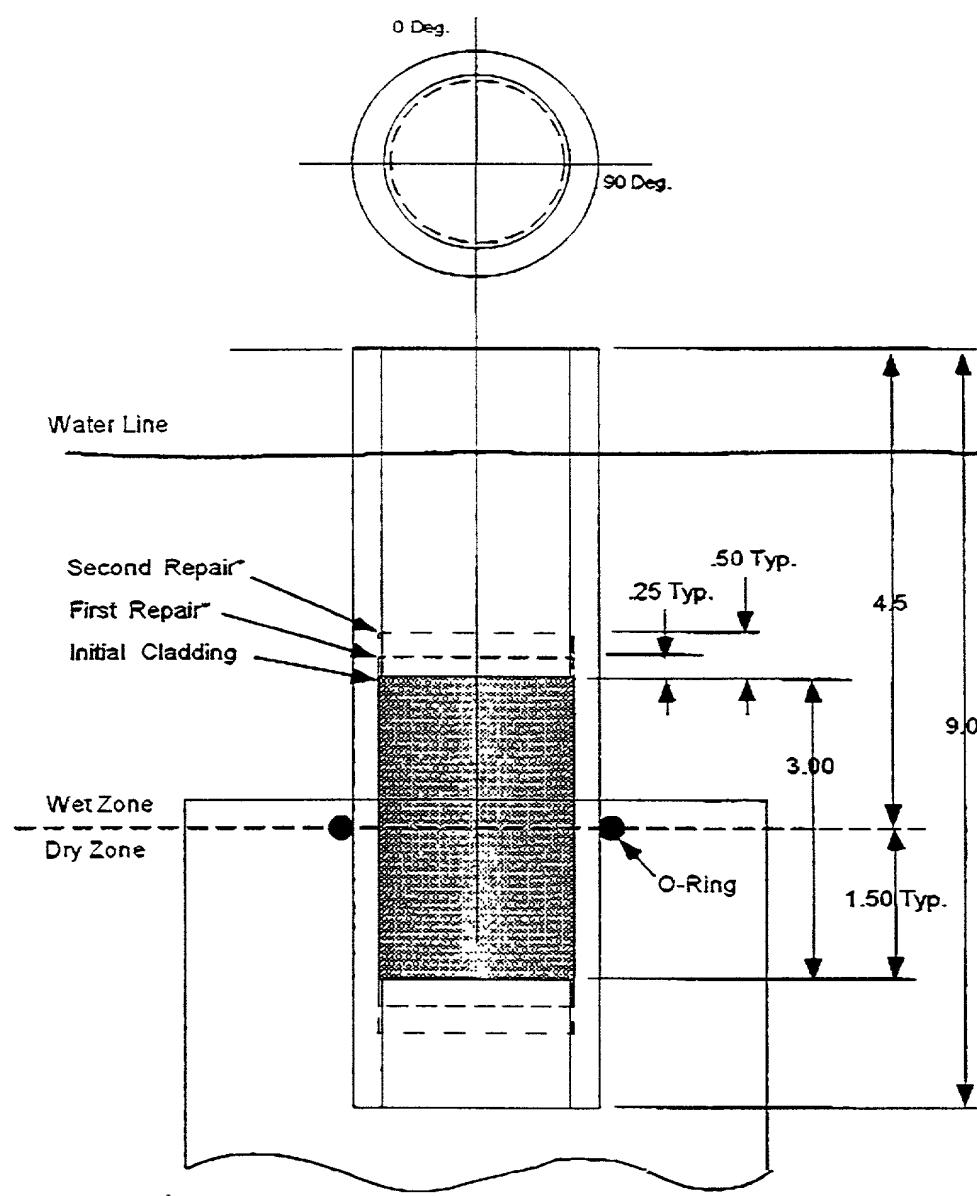
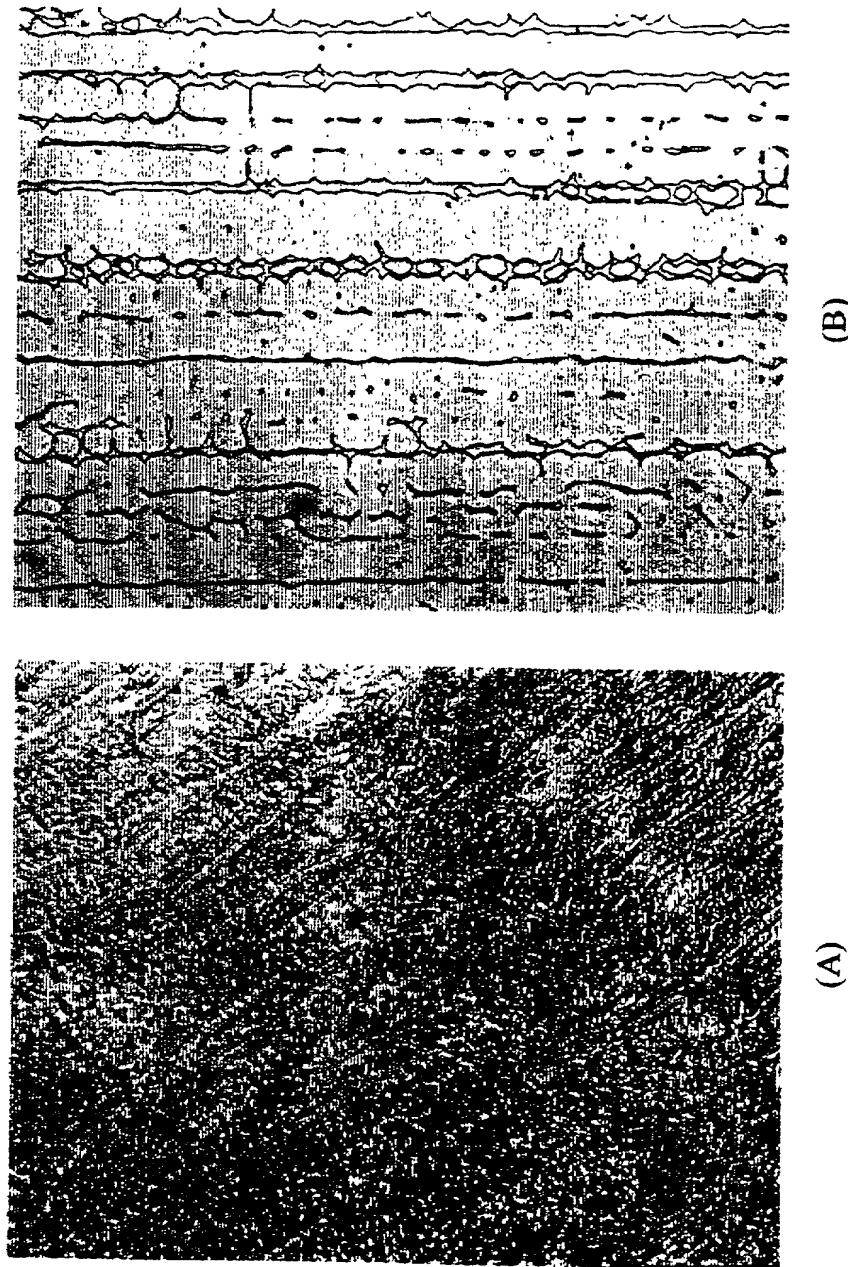


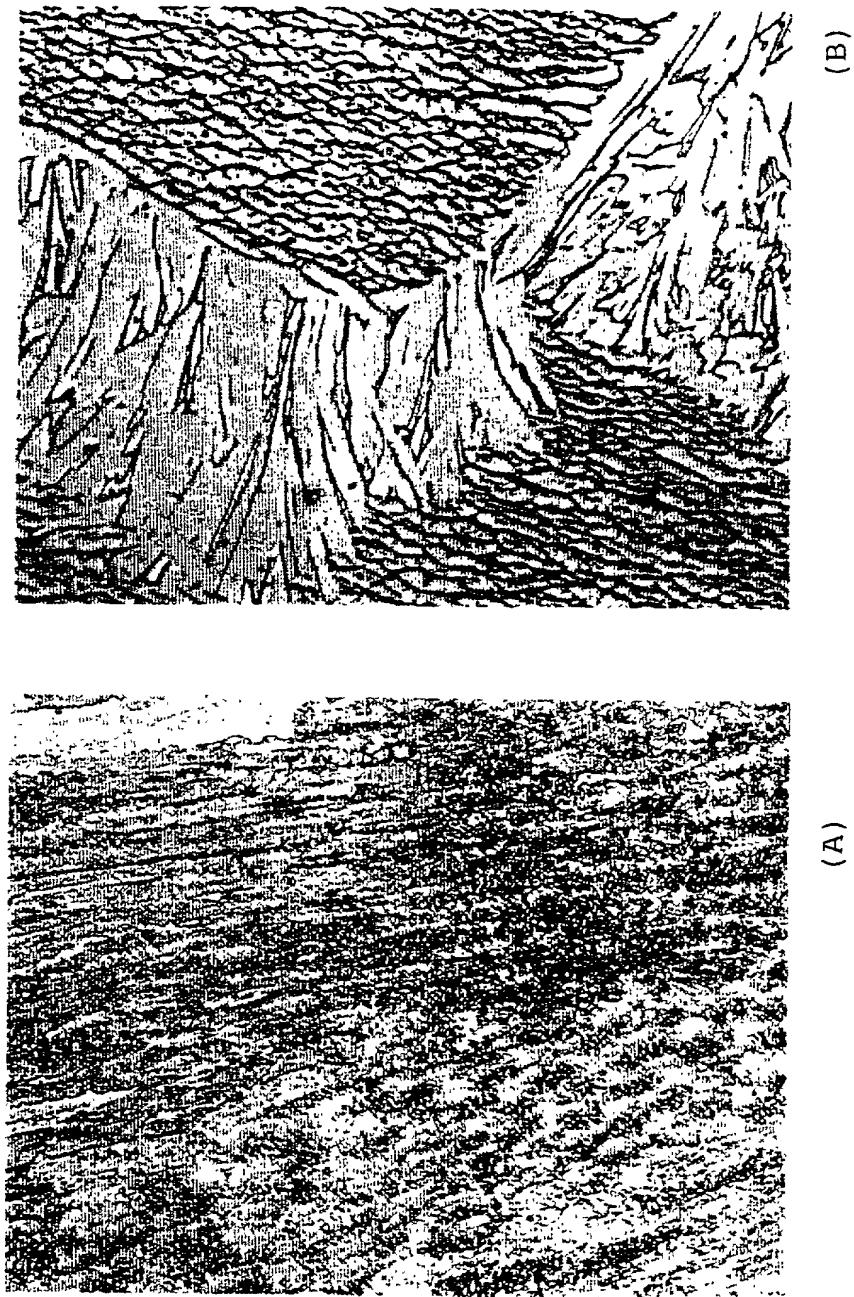
FIG. 7

FIG. 8

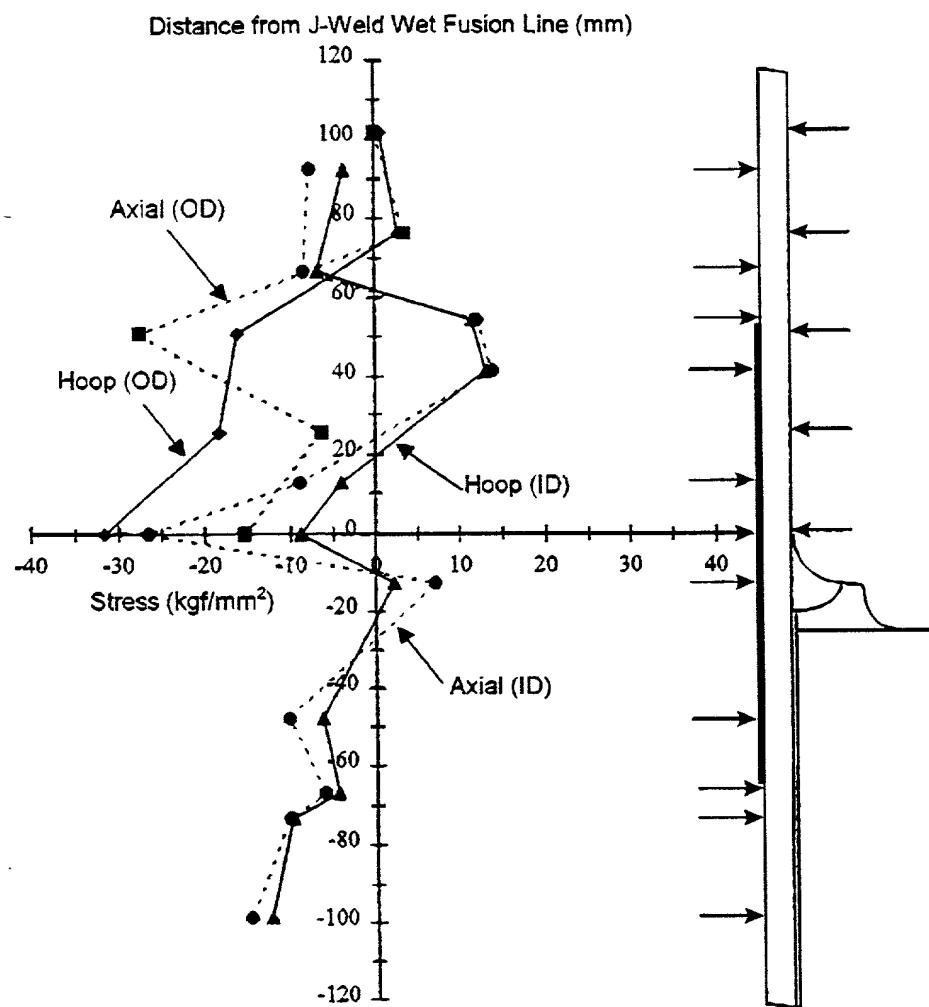


Micrographs Comparing Ferrite Size and Distribution for NM Cladding with Type 316L +1Pd Filler,
800 X Magnification. (A) Mechanized ICMH Cladding, (B) Manual Cladding

Fig. 9

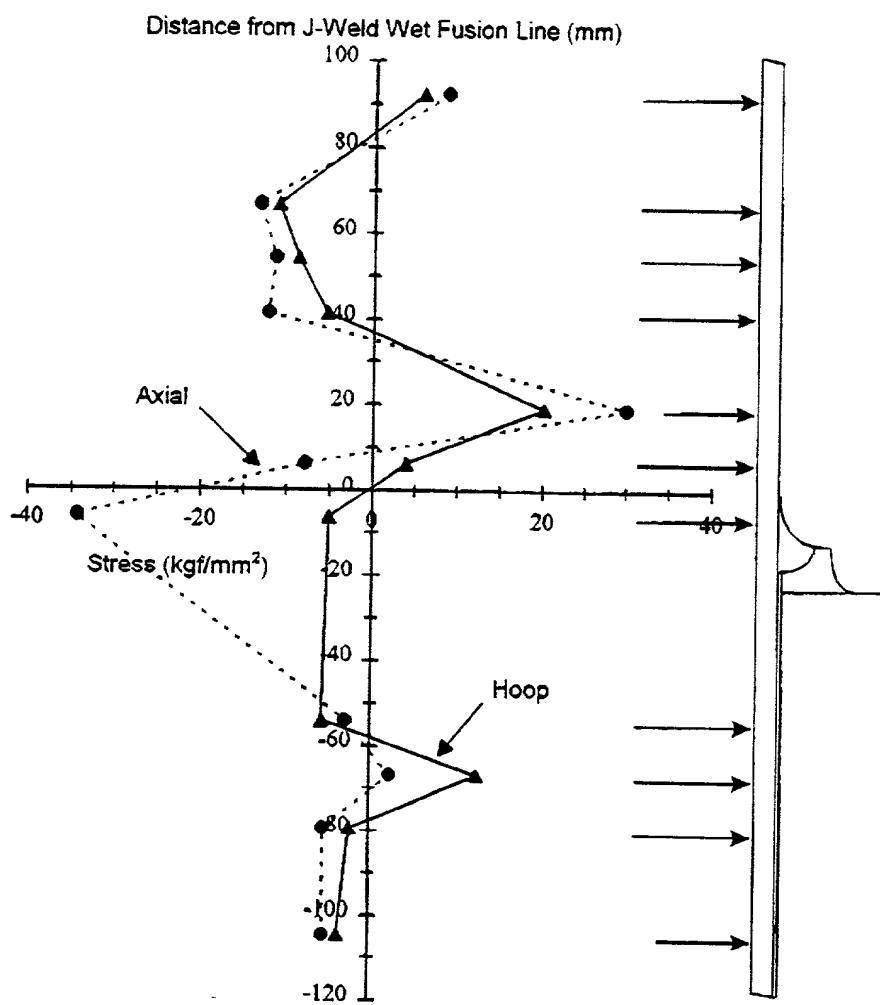


Micrographs Comparing Ferrite Size and Distribution for NM Cladding with Type 308L +1Pt Filler, 800 X Magnification. (A) Mechanized ICMH Cladding, (B) Manual Cladding



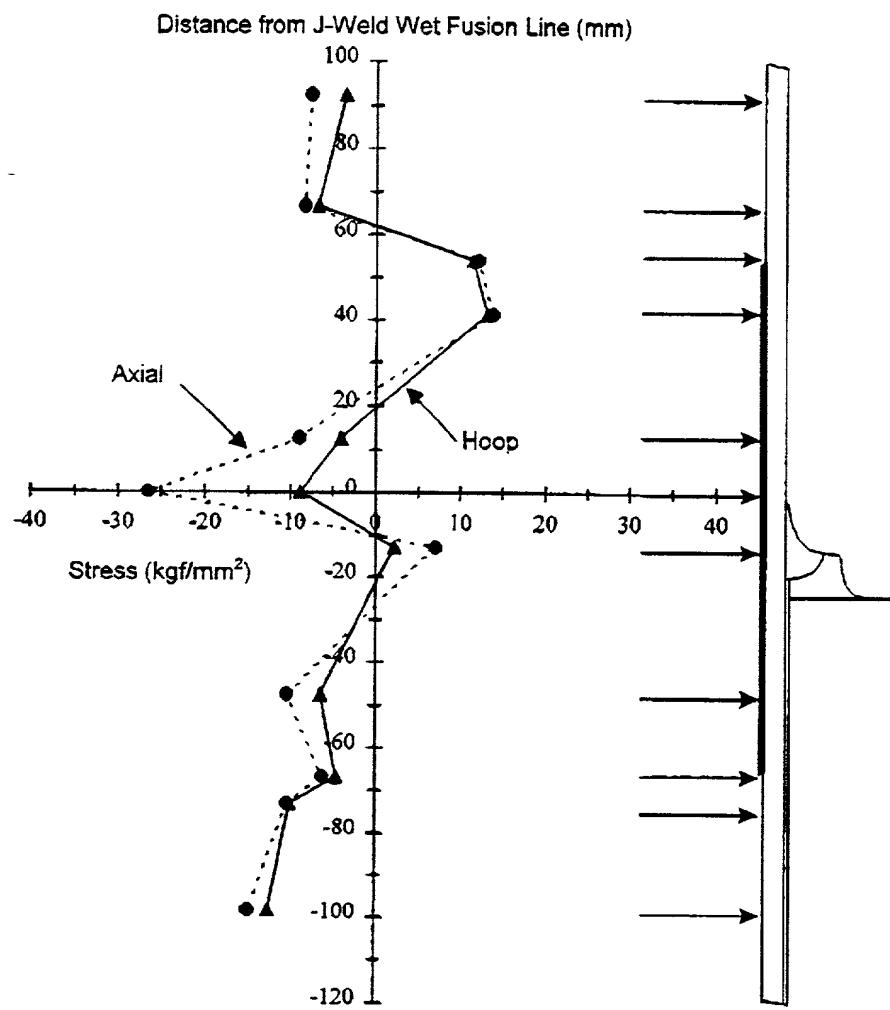
ID/OD Residual Stress (Clad)

FIG. 10A



ID Residual Stress (no clad)

FIG. 10 b



ID Residual Stress (clad)

FIG. 10C